	r ID 115149 7, 2014 2:48:57 PM		*1151	49*						Page 1
Revision ID:	D3561-1  5 3  Seal Insert Tool	561-1	Accept	N900	040	100	)* s	etup Sta	171	S1* S2*
start Date: 3 Required Date: 3 Reference:	8/17/14 <b>Start Qty:</b> 8.00	) <b>*8*</b>		Cust Item 1 Customer:						
	Process Plan: QC:	Date: \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Tooling:  SPC (Y/N):		ate:		R	dun Star Sto	P	R1* R2*
equence ID/ Vork Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr							£.,.		
D3561	Rev A									
00  *1 AA* Waterjet LOW CNC Waterjet		per Dwg D3561 Dwg Rev: f necessary	0.00 0.00 A Prog Rev: A	2-			_8_	0		JM14-05-10
10 *11	QC2- Inspect parts of Memo	ff machine FAI/FAIB	0.00				8_	٥		Jm14-05-10
20 <b>*1<i>2</i>0*</b> QC	QC8- Inspect parts -	second check	0.00 DAS 27 0.00 489	. · <b>(</b>			8			<u> </u>

Quality Control

DQA:			Date:												
						WORK ORDER NON-	-C(	ONFO	RMANCE / UF						AEROSPACE
QA Closed:			Date:		-						Wo	ork Order u	odate only		
Work Ord	er:					DISPOSITION				AGAINST	DEI	PARTMENT	/PROCESS		
		<del></del>				Rework			Skid-tube	Crosstube			Water Jet	-	Engineering
Part I	No.					Scrap	٠,		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	-	<del></del>				Use-as-is			noforming	Finishing			re/Packaging		Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite			Supplier		
												•			
Root	Ì				Desci	ription of work order update	ı	Initial	Acti	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	1	QC Inspector
Design	Ш			•											
Doc/Data															
Equip/Tooling												-			
Handling/Pre															
Material	Ш														
Operator	Ш					:									
Offset/Setup															
Process	$\vdash$				-						ĺ				
Supplier _ · ·															
Training															
Transport	H														
Unapproved			<u>.                                    </u>				EAI	IIIT CAT	I TEGORY						
Landi	nø G	iear			-	General	IA	OLI CA	LOOKI						
Laitai	$\neg$	Bending				Bend	Γ	] Folio/P	rogram	ſ		Outside Dim	ensions	-	Pressure/Forced
	-	Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under			Set-up
	Н	Cracks				Broken/Damage/Defect		Hardwa	re	ļ	$\dashv$	Part Incorred	1		Temperature/Cure
	-	Crimp/Kir	nk/Ripple	/Wave		Burrs	<u> </u>	4	ion Incomplete/Un	qualified	_	Part Lost/Mi	ł		Weld
	-	Cuffs				Contamination		1	ions Incomplete/U	The state of the s	_	Part Moved	_		Wrong Stock Pulled
		Crushing				Countersink	_	4	ned/off center	ļ	$\overline{}$	Positioned V	ر Vrong		• - į
	$\boldsymbol{\vdash}$	Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misread	d						
	-	Marks/Ch				Drill Holes		Off-set							
		Turning S	equence			Finish		Out of (	Calibration						
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence						

Work Ord Monday, March				*115	149*						Page 2
Item ID: Revision ID: Item Name:	D3561-1 Seal Insert T	ool		Accept	*N9000	401	იი*	Setu	p Star Stop	1.71	S1* S2*
Start Date: Required Date: Reference:	3/17/14 3/17/14	Start Qty: 8.00 Req'd Qty: 8.00	* <u>8</u> *		Cust Item ID: Customer:					1.4	
Approvals:	Process Pl		Date:	Tooling:	Date:			Run	Start Stop	^IVI	R1*
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab		Operation Description  Small Fab  Memo Deburr if ne		SPC (Y/N):  Set Up/ Run Hours 0.00  0.00	Tool ID To	ool# Pl	an Accode Qty		eject Ity	Reject Number	R2* Insp. Stamp
140 <b>*1 1 1 1 1 1 1 1 1 1 </b>		NC BRAKE  Memo  Form as per	Dwg D3561	0.00		DAS 30 9-89	_4	)			14/05/

150

\*150\*

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

DQA:			. Date:		_										DART
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / U		W	ork Order u	odate only		AEROSPACE
Work Orde	ır.				-	DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part N	۱o. ِ				_	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update		nitial	Ad	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	<sub>Ch</sub>	ief Eng	Desc	cription		Date	Verification	1	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved			·					J		•					
							FAI	JLT CAT	EGORY						
Landii		Gear Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple nt n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Uions Incomplete, ned/off center	/Unclear		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence						1

Work Ord Monday, March				*11 <i>5</i>	5149*							Page	3
Item ID: Revision ID: Item Name:	D3561-1 Seal Insert T	ool		Accept	*N900	<b>04</b> 0	100	)*	Setup	Start Stop	17	S1*	
Start Date: Required Date: Reference:	3/17/14 3/17/14	Start Qty: 8.00 Req'd Qty: 8.00	* <u>8</u> * * <u>8</u> *		Cust Item I Customer:	D:					IU	. 12	
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		nte:	-	I	Run	Start Stop	^I\/I	R1* R2*	
Sequence ID/ Work Center II 160 *1 AO* Packaging Packaging	)	Operation Description Identify as per dwg & St  Memo	ock Location: 816	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	D: 2

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

Quality Control

Memo

0.00

MLJ 440577

DQA:			- Date:			. WORK ORDER NON	~	281501		DDATE					"DART
QA Closed:	-0	= -	Date:			WORK ORDER NON-	-((	JNFOI	RIVIANCE / UI		Wo	rk Order up	odate only	$\neg$	AEROSPACE
Work Ord	er.					DISPOSITION				AGAINST I	DEF	PARTMENT	/PROCESS		
Part NCR N	No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desci	ription of work order update		nitial	Act	ion	I	Sign &			•
Cause		Date	Step	Qty		or non-conformance		ief Eng		ription		Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
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Landi	ng (	Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea	nk/Ripple			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short		Grain Hardwa Inspecti Instruct	on Incomplete/Un ions Incomplete/U ned/off center	· -		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance ct sssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	Г	Inspectio		Tube		Drawing	<b></b>	Misread		_		-,	÷ L		
		Marks/Ch	•			Drill Holes		Off-set			-				!
		Turning S	equence			Finish		Out of 0	Calibration		_				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence						·

**Picklist Print** 

Monday, March 17, 2014 2:48:56 PM

Work Order ID: 115149

\*115149\*

Parent Item:

D3561-1

\*D3561-1\*

Parent Item Name: Seal Insert Tool

**Start Date:** 3/17/14

Required Date: 3/17/14

Start Qty: 8.00

Required Qty: 8.00

**Comments:** 

IPP: A06.10.19New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No		100	sf	210.5000	0.0473	$\overline{\bigcirc}$		* 99	-
*1/120/1211	1 C A *							**				

Wi3U4つ I I(JA

304/316 0.125 Sheet

Location		Loc Qty	Loc Code	
MAT020		210.5		
	122521	36		
	M128254	174.5		178254

DQA:			Date:										Ì	TRAC <sup>~</sup>
QA Closed:			Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UF		Vork Order u	odate only	$\neg$	AEROSPACE
Work Orde	) r·					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part N	- ۱٥٠					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	<del></del>	Water Jet d. Eng. Coor. re/Packaging		Engineering Quality Other
NCR N	NO	· ·-		<del></del>		Suspected Unapproved			Large Fab	Composite		Supplier		. $\square$
Root Cause		Date	Step	Qty	Desci	ription of work order update or non-conformance	i i	Initial lief Eng	Acti Descri		Sign & Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														;
							FAI	ULT CAT	TEGORY					1
Landi		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea	at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Un tions Incomplete/U gned/off center eled d	·	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled
		Wave/Tw	ist in Tub	e		Fit/Function		Out of s	Sequence					1

DART AEROSPACE LTD	Work Order:	115149
Description: Seal Insert Tool	Part Number:	D3561-1
Inspection Dwg: D3561 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

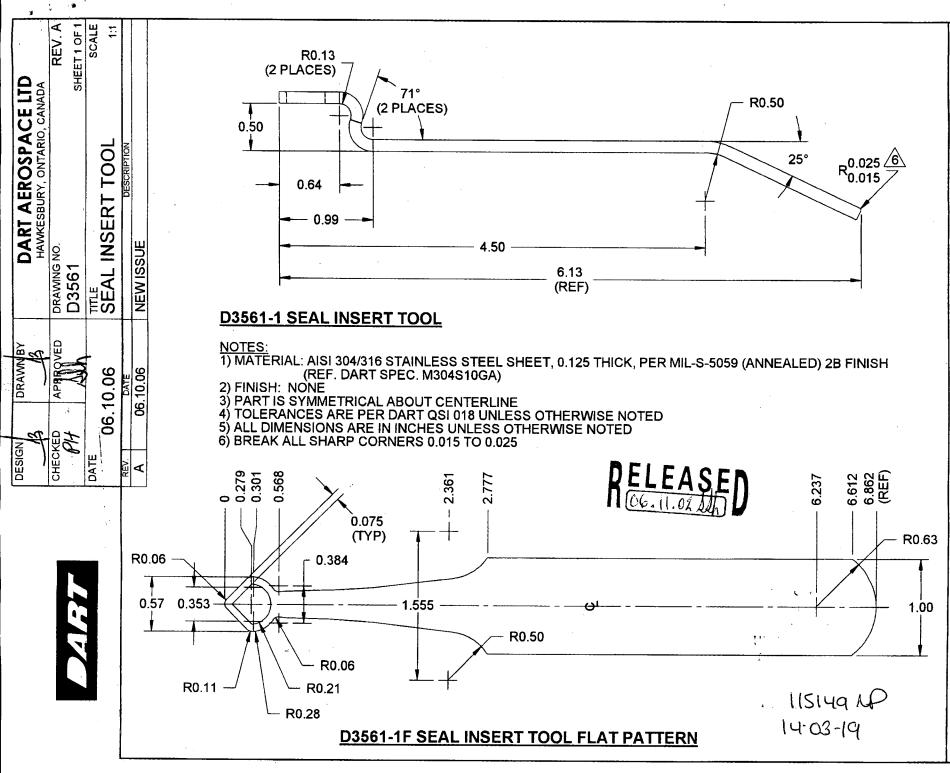
X First Article Prototype

	<u> </u>		<u> </u>			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1,005	_		V	JAmo 5
2.777	+/-0.010	2.777	-		V	
0.57	+/-0.030	0.57	_		V	
R0.06	+/-0.030		_		RG	
R0.28	+/-0.030	0.06	_		RG	
0.075	+/-0.030	6.078	-		V	
				,		
			DAS			

Measured by: J Audited by: 9-89 Prototype Approval: N/A

Date: (4-05-6) Date: 14/5/12 Date: N/A

Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM 🛠	B



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